Work Order ID 65711

Monday, January 24, 2011 10:36:21 AM

Item ID: D2432 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: 206 (24") Bearpaw

Start Date: 1/25/2011 **Start Qty:** 16.00 **Cust Item ID:**

Required Date: 2/8/2011 **Req'd Qty:** 16.00 **Customer:**

Reference:

Approvals: **Process Plan:** MF **Date:** 11-01-24 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2432	Rev F3								
120	FLOW WATER JET	0.00							
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	Cut Blank as per D2432 File					BL 11-2-16			
130	HAAS CNC VERTICAL MACHINING #1	0.00							
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine#1	1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Deburr	JL 11/03/16				(16)			
Batch Prog. JW									
140	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00				JL 11/03/16			
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 65711

Monday, January 24, 2011 10:36:21 AM

Item ID: D2432 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: 206 (24") Bearpaw

Start Date: 1/25/2011 **Start Qty:** 16.00 **Cust Item ID:**

Required Date: 2/8/2011 **Req'd Qty:** 16.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC8- Inspect parts - second check	0.00				16	0		
	Memo	0.00	ank 11/03/17						
151 Packaging Packaging	Identify as per dwg & Stock Location:_____	0.00							
	Memo PPA 65710	0.00				11/3/17 (16)			
190 QC Quality Control	QC21- Final Inspection - Work Order Release	0.00					11/3/17		
	Memo	0.00							

11-03-17 (16)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Monday, January 24, 2011 10:36:18 AM

Work Order ID: 65711

Parent Item: D2432

Parent Item Name: 206 (24") Bearpaw

Start Date: 1/25/2011 **Required Date:** 2/8/2011

Start Qty: 16.00 **Required Qty:** 16.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 UHMW 1" Black		Purchased	No			120	sf	189.8794	3.7	59.2			

R 10-2-10

Location	Loc Qty	Loc Code	
MAT	189.8794		
114624	5.2734		
115325	15.506		
115955	38.8		
116281	13		
116554	117.3		116796 X
			116797 X

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	65711
Description: Bearpaw	Part Number:	D2432
Inspection Dwg: D2432 **Rev:** F3		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.06X45°	✓		Vern. 2L-3	
B	5.500	+/-0.030	5.505	✓		"	
C	0.200	+/-0.030	.198	✓		"	
D	0.25 x 45°	+/-0.030	.250X45°	✓		"	
E	R0.250	+/-0.030	.250	✓		R-G	
F	0.250	+/-0.010	.250	✓		"	
G	0.625	+/-0.030	.620	✓		"	
H	0.375	+/-0.010	.373	✓		"	
I	0.950	+0.030/0.010	.951	✓		"	
J	19.000	+/-0.030	19.00	✓		m-tape	
K	3.14	+/-0.030	3.150	✓		"	
L	3.28	+/-0.030	3.290	✓		"	
M	Ø0.260	+0.005/-0.000	.260	✓		"	
N	Ø0.93	+/-0.030	.925	✓		"	
O	0.30	+0.030/-0.000	.310	✓		"	
P	23.750	+/-0.030	23.750	✓		m-tape	
Q	7.375	+/-0.030	7.373	✓		Vern (VC-02)	
R	4.250	+/-0.010	4.250	✓		"	
S	2.000	+/-0.030	2.001	✓			
T	9.000	+/-0.010	9.00	✓			
U	9.000	+/-0.010	9.00	✓			
V	0.375	+/-0.010	.381	✓			

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	11/03/15	Date:	11/03/17	Date:	

Rev	Date	Change		Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

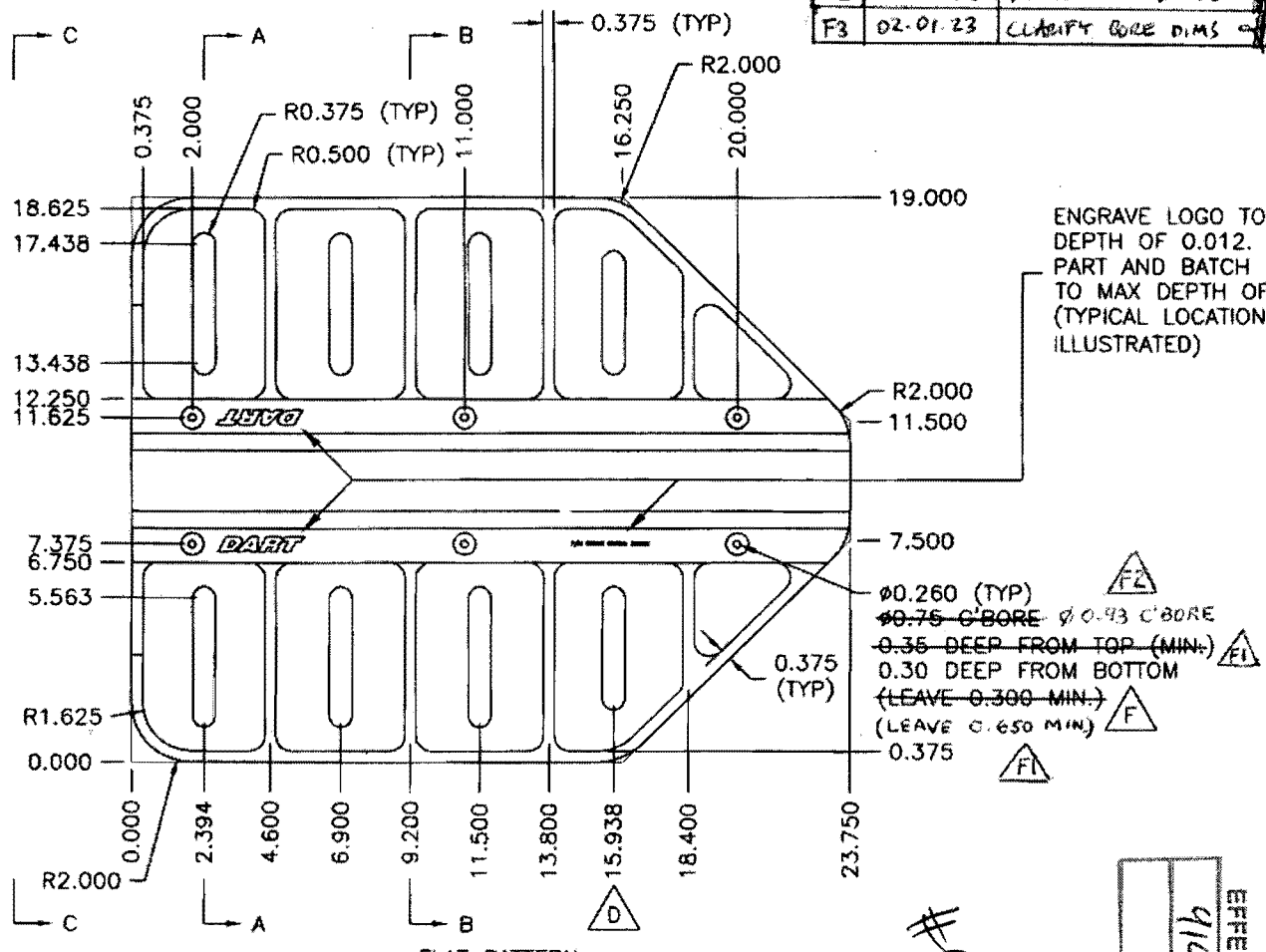
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

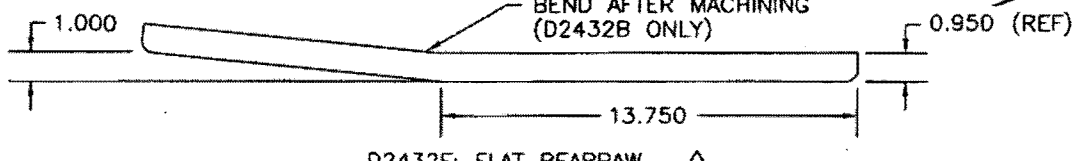
NOTE: Date & initial all entries

F1	99.03.03	ADD DEO 9143
F2	01.03.28	⌀0.93 WAS ⌀0.75 RF
F3	02.01.23	CLARIFY BORE DIMS RF

RELEASED 98.06.17 KE



FLAT PATTERN



D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW F

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

#05711

EFFECTIVE DEOs 9143

A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

DART

U.S. COPYRIGHTED

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD
CHECKED MM	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE 98.05.12	DRAWING NO. D2432	REV. F
	TITLE BEARPAW	SHEET 1 OF 2
		SCALE 1:6

Copyright 1995 by DART AEROSPACE LTD

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

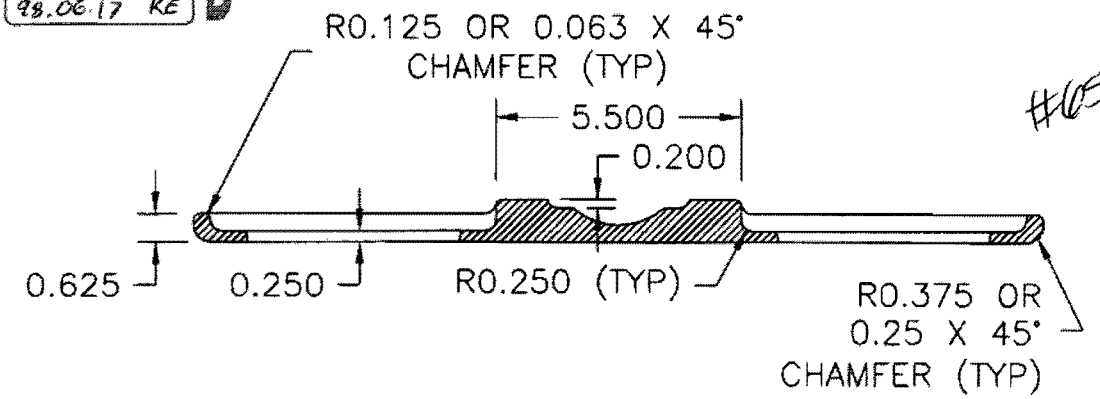
NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
KE	KE		
CHECKED	APPROVED	DRAWING NO.	REV. F
		D2432	SHEET 2 OF 2
DATE		TITLE	SCALE
98.05.12		BEARPAW	1:4

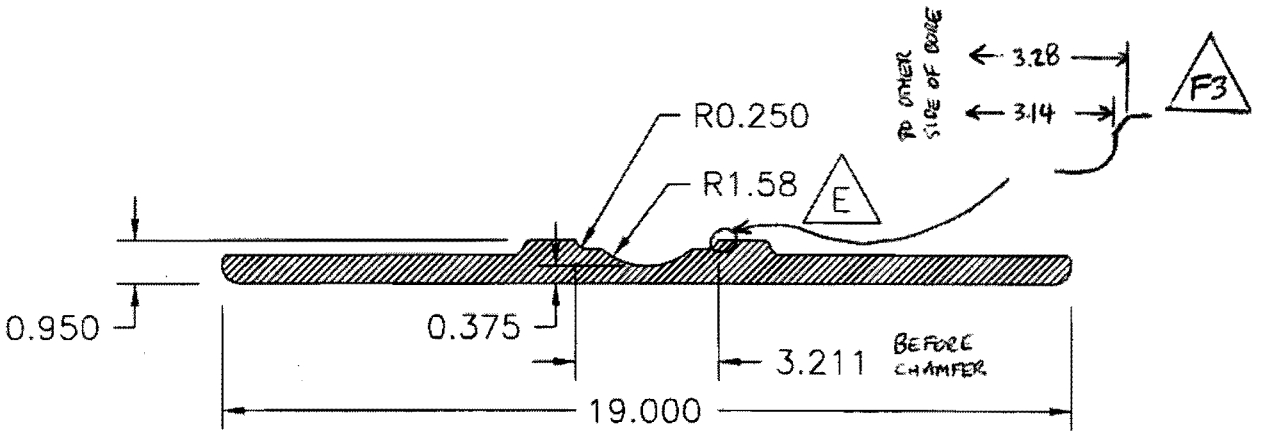
COPY ISSUED

RELEASED
98.06.17 KE

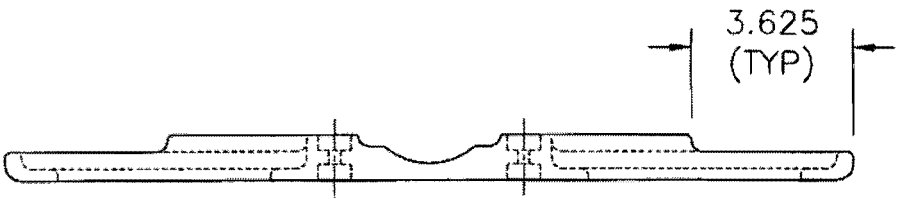
#105711



SECTION A–A



SECTION B–B



SECTION C–C

Copyright 1995 by DART AEROSPACE LTD

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries